

NPA

New Product Announcement

MILLING

48-2024

AUGUST 2024

METRIC



High Precision Tools



High Productivity



New Generation Tools



SOLIDMILL
PREMIUM LINE

NEW EC-A2 Replaces Existing Tool Line



High
Precision Tools



High
Productivity



New
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PREMIUM LINE

Highlights

- **The Ultimate Solution to Machining Hard Materials. Optimized Geometry for Improved Tool Rigidity and Better Performance.**
- **A Broad Range of Tools Expand the Current Tool Line.**
- **Available in Flat Face or Round Radius End Face Options.**
- **High Precision Tools.**

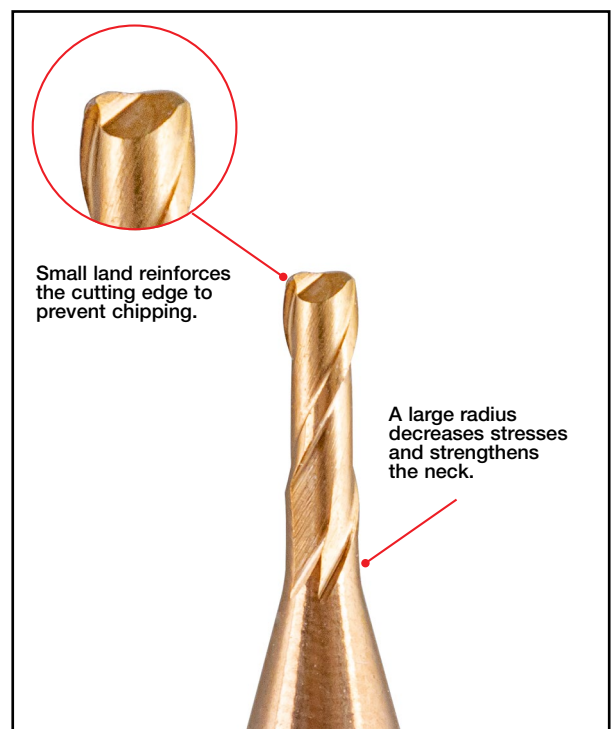
ISCAR will phase out the **EC-A2** line in the diameter ranges of 0.3-4 mm to be replaced by new tools with a similar description. The new tools will replace the old generation tools once the inventory is depleted.

The new **EC-A2** line for machining high hardened steel of up to 65 HRC will be used with IC602, an ultra fine carbide substrate that features high hardness and AlTiCrSiN PVD coating that assures extended tool life. The endmill's optimized shape enables higher productivity and improved performance.

The new tools feature tighter tolerances pertaining to the tool diameter and the corner radius for higher accuracy:

Diameter tolerance: 0/-10 μm

Corner radius tolerance: $\pm 5 \mu\text{m}$



Small land reinforces the cutting edge to prevent chipping.

A large radius decreases stresses and strengthens the neck.

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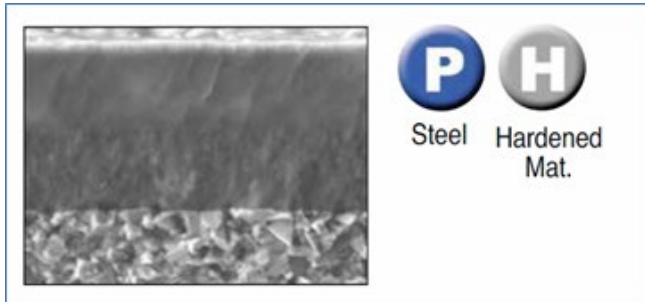
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Recommended Applications

- Machining pre-hardened and hardened steel of up to 65 HRc, tool steel, HSS, cold-worked and hot-worked die steel categorized as D2 or H13.
- An excellent solution for the die and mold industry in roughing and finishing applications.
- Suitable for dry or wet machining.



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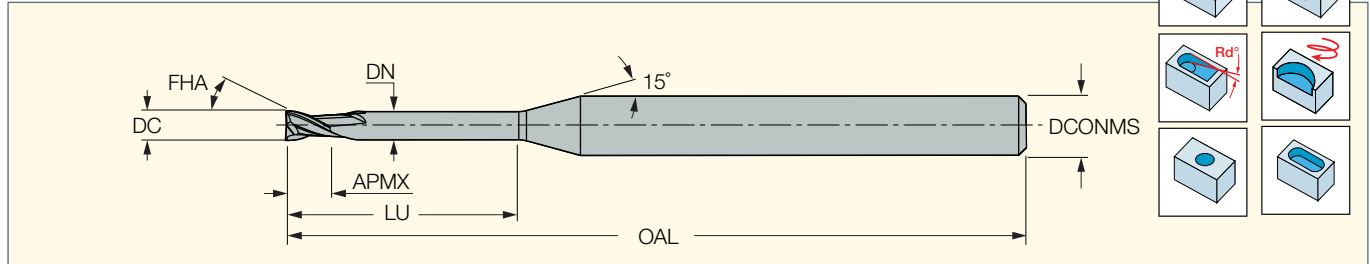
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EC-A2-T

2 Flute Endmill for High-Speed Machining Hardened Steel of Up to 65 HRC

<https://www.iscar.com/eCatalog/Family.aspx?fnum=5132&mapp=ML&GFSTYP=M&srch=1>



Designation	Dimensions									IC602	Recommended Machining Data
	DC	DCONMS	APMX	LU	OAL	DN	NOF ⁽¹⁾	FHA	Shank		f _z (mm/t)
EC-A2 003-04/1C4H45T	0.30	4.00	0.40	1.0	45.00	0.27	2	30.0	C	●	0.0060-0.0100
EC-A2 003-04/15C4H45T	0.30	4.00	0.40	1.5	45.00	0.27	2	30.0	C	●	0.0060-0.0100
EC-A2 003-04/2C4H45T	0.30	4.00	0.40	2.0	45.00	0.27	2	30.0	C	●	0.0060-0.0100
EC-A2 003-04/25C4H45T	0.30	4.00	0.40	2.5	45.00	0.27	2	30.0	C	●	0.0060-0.0100
EC-A2 003-04/3C4H45T	0.30	4.00	0.40	3.0	45.00	0.27	2	30.0	C	●	0.0060-0.0100
EC-A2 003-04/4C4H45T	0.30	4.00	0.40	4.0	45.00	0.27	2	30.0	C	●	0.0050-0.0080
EC-A2 003-04/5C4H45T	0.30	4.00	0.40	5.0	45.00	0.27	2	30.0	C	●	0.0050-0.0080
EC-A2 004-06/1C4H45T	0.40	4.00	0.60	1.0	45.00	0.37	2	30.0	C	●	0.0060-0.0100
EC-A2 004-06/15C4H45T	0.40	4.00	0.60	1.5	45.00	0.37	2	30.0	C	●	0.0060-0.0100
EC-A2 004-06/2C4H45T	0.40	4.00	0.60	2.0	45.00	0.37	2	30.0	C	●	0.0060-0.0100
EC-A2 004-06/25C4H45T	0.40	4.00	0.60	2.5	45.00	0.37	2	30.0	C	●	0.0060-0.0100
EC-A2 004-06/3C4H45T	0.40	4.00	0.60	3.0	45.00	0.37	2	30.0	C	●	0.0060-0.0100
EC-A2 004-06/4C4H45T	0.40	4.00	0.60	4.0	45.00	0.37	2	30.0	C	●	0.0060-0.0100
EC-A2 004-06/5C4H45T	0.40	4.00	0.60	5.0	45.00	0.37	2	30.0	C	●	0.0050-0.0080
EC-A2 004-06/6C4H45T	0.40	4.00	0.60	6.0	45.00	0.37	2	30.0	C	●	0.0050-0.0080
EC-A2 005-07/1C4H45T	0.50	4.00	0.70	1.0	45.00	0.45	2	30.0	C	●	0.0060-0.0100
EC-A2 005-07/15C4H45T	0.50	4.00	0.70	1.5	45.00	0.45	2	30.0	C	●	0.0060-0.0100
EC-A2 005-07/2C4H45T	0.50	4.00	0.70	2.0	45.00	0.45	2	30.0	C	●	0.0060-0.0100
EC-A2 005-07/25C4H45T	0.50	4.00	0.70	2.5	45.00	0.45	2	30.0	C	●	0.0060-0.0090
EC-A2 005-07/3C4H45T	0.50	4.00	0.70	3.0	45.00	0.45	2	30.0	C	●	0.0060-0.0090
EC-A2 005-07/4C4H45T	0.50	4.00	0.70	4.0	45.00	0.45	2	30.0	C	●	0.0060-0.0080
EC-A2 005-07/5C4H45T	0.50	4.00	0.70	5.0	45.00	0.45	2	30.0	C	●	0.0060-0.0080
EC-A2 005-07/6C4H45T	0.50	4.00	0.70	6.0	45.00	0.45	2	30.0	C	●	0.0050-0.0070
EC-A2 005-07/8C4H45T	0.50	4.00	0.70	8.0	45.00	0.45	2	30.0	C	●	0.0050-0.0070
EC-A2 006-09/10C4H45T	0.60	4.00	0.90	10.0	45.00	0.55	2	30.0	C	●	0.0060-0.0100
EC-A2 006-09/2C4H45T	0.60	4.00	0.90	2.0	45.00	0.55	2	30.0	C	●	0.0080-0.0130
EC-A2 006-09/3C4H45T	0.60	4.00	0.90	3.0	45.00	0.55	2	30.0	C	●	0.0080-0.0130
EC-A2 006-09/4C4H45T	0.60	4.00	0.90	4.0	45.00	0.55	2	30.0	C	●	0.0080-0.0130
EC-A2 006-09/5C4H45T	0.60	4.00	0.90	5.0	45.00	0.55	2	30.0	C	●	0.0080-0.0130
EC-A2 006-09/6C4H45T	0.60	4.00	0.90	6.0	45.00	0.55	2	30.0	C	●	0.0080-0.0130
EC-A2 006-09/8C4H45T	0.60	4.00	0.90	8.0	45.00	0.55	2	30.0	C	●	0.0060-0.0100
EC-A2 007-12/10C4H45T	0.70	4.00	1.20	10.0	45.00	0.65	2	30.0	C	●	0.0060-0.0100
EC-A2 007-12/12C4H45T	0.70	4.00	1.20	12.0	45.00	0.65	2	30.0	C	●	0.0060-0.0100
EC-A2 007-12/2C4H45T	0.70	4.00	1.20	2.0	45.00	0.65	2	30.0	C	●	0.0080-0.0130
EC-A2 007-12/4C4H45T	0.70	4.00	1.20	4.0	45.00	0.65	2	30.0	C	●	0.0080-0.0130
EC-A2 007-12/6C4H45T	0.70	4.00	1.20	6.0	45.00	0.65	2	30.0	C	●	0.0080-0.0130
EC-A2 007-12/8C4H45T	0.70	4.00	1.20	8.0	45.00	0.65	2	30.0	C	●	0.0080-0.0130
EC-A2 008-12/10C4H45T	0.80	4.00	1.20	10.0	45.00	0.73	2	30.0	C	●	0.0070-0.0120
EC-A2 008-12/12C4H45T	0.80	4.00	1.20	12.0	45.00	0.73	2	30.0	C	●	0.0070-0.0120
EC-A2 008-12/2C4H45T	0.80	4.00	1.20	2.0	45.00	0.75	2	30.0	C	●	0.0070-0.0150
EC-A2 008-12/3C4H45T	0.80	4.00	1.20	3.0	45.00	0.75	2	30.0	C	●	0.0070-0.0150

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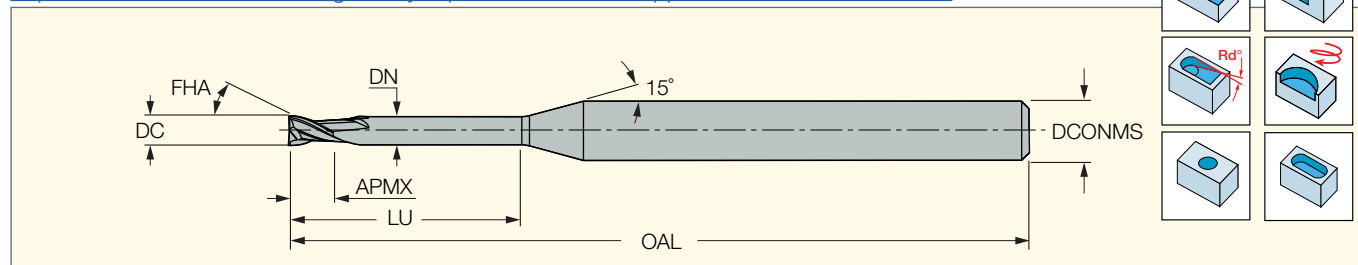
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<https://www.iscar.com/eCatalog/Family.aspx?num=5132&mapp=ML&GFSTYP=M&srch=1>



Designation	Dimensions									IC602	Recommended Machining Data
	DC	DCONMS	APMX	LU	OAL	DN	NOF ⁽¹⁾	FHA	Shank		f _z (mm/t)
EC-A2 008-12/4C4H45T	0.80	4.00	1.20	4.0	45.00	0.75	2	30.0	C	●	0.0070-0.0150
EC-A2 008-12/5C4H45T	0.80	4.00	1.20	5.0	45.00	0.75	2	30.0	C	●	0.0070-0.0150
EC-A2 008-12/6C4H45T	0.80	4.00	1.20	6.0	45.00	0.75	2	30.0	C	●	0.0070-0.0150
EC-A2 008-12/8C4H45T	0.80	4.00	1.20	8.0	45.00	0.73	2	30.0	C	●	0.0070-0.0130
EC-A2 010-15/10C4H50T	1.00	4.00	1.50	10.0	50.00	0.95	2	30.0	C	●	0.0090-0.0160
EC-A2 010-15/12C4H50T	1.00	4.00	1.50	12.0	50.00	0.93	2	30.0	C	●	0.0080-0.0140
EC-A2 010-15/14C4H50T	1.00	4.00	1.50	14.0	50.00	0.93	2	30.0	C	●	0.0080-0.0140
EC-A2 010-15/16C4H50T	1.00	4.00	1.50	16.0	50.00	0.91	2	30.0	C	●	0.0080-0.0140
EC-A2 010-15/18C4H55T	1.00	4.00	1.50	18.0	55.00	0.91	2	30.0	C	●	0.0080-0.0120
EC-A2 010-15/20C4H55T	1.00	4.00	1.50	20.0	55.00	0.85	2	30.0	C	●	0.0080-0.0120
EC-A2 010-15/3C4H50T	1.00	4.00	1.50	3.0	50.00	0.97	2	30.0	C	●	0.0090-0.0200
EC-A2 010-15/4C4H50T	1.00	4.00	1.50	4.0	50.00	0.97	2	30.0	C	●	0.0090-0.0200
EC-A2 010-15/5C4H50T	1.00	4.00	1.50	5.0	50.00	0.97	2	30.0	C	●	0.0090-0.0180
EC-A2 010-15/6C4H50T	1.00	4.00	1.50	6.0	50.00	0.97	2	30.0	C	●	0.0090-0.0180
EC-A2 010-15/7C4H50T	1.00	4.00	1.50	7.0	50.00	0.97	2	30.0	C	●	0.0090-0.0180
EC-A2 010-15/8C4H50T	1.00	4.00	1.50	8.0	50.00	0.95	2	30.0	C	●	0.0090-0.0180
EC-A2 012-18/10C4H50T	1.20	4.00	1.80	10.0	50.00	1.15	2	30.0	C	●	0.0100-0.0190
EC-A2 012-18/12C4H50T	1.20	4.00	1.80	12.0	50.00	1.15	2	30.0	C	●	0.0100-0.0180
EC-A2 012-18/16C4H50T	1.20	4.00	1.80	16.0	50.00	1.13	2	30.0	C	●	0.0100-0.0180
EC-A2 012-18/4C4H50T	1.20	4.00	1.80	4.0	50.00	1.17	2	30.0	C	●	0.0100-0.0200
EC-A2 012-18/6C4H50T	1.20	4.00	1.80	6.0	50.00	1.17	2	30.0	C	●	0.0100-0.0200
EC-A2 012-18/8C4H50T	1.20	4.00	1.80	8.0	50.00	1.15	2	30.0	C	●	0.0100-0.0200
EC-A2 015-23/10C4H50T	1.50	4.00	2.30	10.0	50.00	1.45	2	30.0	C	●	0.0150-0.0250
EC-A2 015-23/12C4H50T	1.50	4.00	2.30	12.0	50.00	1.43	2	30.0	C	●	0.0130-0.0250
EC-A2 015-23/14C4H50T	1.50	4.00	2.30	14.0	50.00	1.43	2	30.0	C	●	0.0130-0.0250
EC-A2 015-23/16C4H50T	1.50	4.00	2.30	16.0	50.00	1.41	2	30.0	C	●	0.0110-0.0150
EC-A2 015-23/18C4H55T	1.50	4.00	2.30	18.0	55.00	1.41	2	30.0	C	●	0.0110-0.0150
EC-A2 015-23/20C4H55T	1.50	4.00	2.30	20.0	55.00	1.41	2	30.0	C	●	0.0110-0.0150
EC-A2 015-23/4C4H50T	1.50	4.00	2.30	4.0	50.00	1.47	2	30.0	C	●	0.0150-0.0250
EC-A2 015-23/6C4H50T	1.50	4.00	2.30	6.0	50.00	1.47	2	30.0	C	●	0.0150-0.0250
EC-A2 015-23/8C4H50T	1.50	4.00	2.30	8.0	50.00	1.45	2	30.0	C	●	0.0150-0.0250
EC-A2 020-30/10C4H50T	2.00	4.00	3.00	10.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 020-30/12C4H50T	2.00	4.00	3.00	12.0	50.00	1.93	2	30.0	C	●	0.0160-0.0250
EC-A2 020-30/14C4H50T	2.00	4.00	3.00	14.0	50.00	1.93	2	30.0	C	●	0.0160-0.0250
EC-A2 020-30/16C4H50T	2.00	4.00	3.00	16.0	50.00	1.91	2	30.0	C	●	0.0150-0.0220
EC-A2 020-30/18C4H55T	2.00	4.00	3.00	18.0	55.00	1.91	2	30.0	C	●	0.0150-0.0220
EC-A2 020-30/20C4H55T	2.00	4.00	3.00	20.0	55.00	1.91	2	30.0	C	●	0.0130-0.0190
EC-A2 020-30/25C4H60T	2.00	4.00	3.00	25.0	60.00	1.91	2	30.0	C	●	0.0130-0.0190
EC-A2 020-30/30C4H70T	2.00	4.00	3.00	30.0	70.00	1.91	2	30.0	C	●	0.0100-0.0150
EC-A2 020-30/4C4H50T	2.00	4.00	3.00	4.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 020-30/6C4H50T	2.00	4.00	3.00	6.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 020-30/8C4H50T	2.00	4.00	3.00	8.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400

⁽¹⁾ Number of flutes

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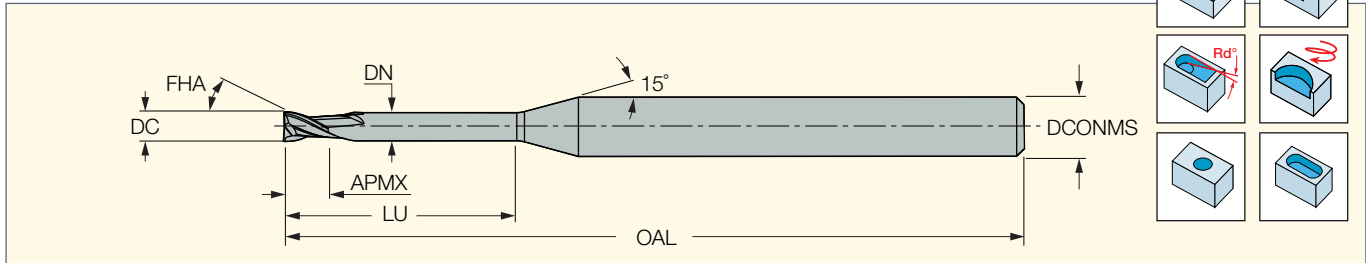
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	DC	DCONMS	APMX	LU	OAL	DN	NOF ⁽¹⁾	FHA	Shank		f _z (mm/t)
EC-A2 025-40/10C4H50T	2.50	4.00	4.00	10.0	50.00	2.40	2	30.0	C	●	0.0190-0.0450
EC-A2 025-40/12C4H50T	2.50	4.00	4.00	12.0	50.00	2.40	2	30.0	C	●	0.0170-0.0400
EC-A2 025-40/16C4H50T	2.50	4.00	4.00	16.0	50.00	2.40	2	30.0	C	●	0.0150-0.0300
EC-A2 025-40/20C4H55T	2.50	4.00	4.00	20.0	55.00	2.40	2	30.0	C	●	0.0130-0.0200
EC-A2 025-40/8C4H50T	2.50	4.00	4.00	8.0	50.00	2.40	2	30.0	C	●	0.0190-0.0450
EC-A2 030-45/10C6H55T	3.00	6.00	4.50	10.0	55.00	2.85	2	30.0	C	●	0.0210-0.0600
EC-A2 030-45/12C6H55T	3.00	6.00	4.50	12.0	55.00	2.85	2	30.0	C	●	0.0180-0.0500
EC-A2 030-45/14C6H55T	3.00	6.00	4.50	14.0	55.00	2.85	2	30.0	C	●	0.0180-0.0450
EC-A2 030-45/16C6H55T	3.00	6.00	4.50	16.0	55.00	2.85	2	30.0	C	●	0.0180-0.0450
EC-A2 030-45/18C6H60T	3.00	6.00	4.50	18.0	60.00	2.85	2	30.0	C	●	0.0150-0.0400
EC-A2 030-45/20C6H60T	3.00	6.00	4.50	20.0	60.00	2.85	2	30.0	C	●	0.0150-0.0400
EC-A2 030-45/25C6H60T	3.00	6.00	4.50	25.0	60.00	2.85	2	30.0	C	●	0.0150-0.0400
EC-A2 030-45/30C6H70T	3.00	6.00	4.50	30.0	70.00	2.85	2	30.0	C	●	0.0150-0.0380
EC-A2 030-45/35C6H75T	3.00	6.00	4.50	35.0	75.00	2.85	2	30.0	C	●	0.0150-0.0380
EC-A2 030-45/40C6H80T	3.00	6.00	4.50	40.0	80.00	2.85	2	30.0	C	●	0.0150-0.0300
EC-A2 030-45/8C6H55T	3.00	6.00	4.50	8.0	55.00	2.85	2	30.0	C	●	0.0210-0.0600
EC-A2 040-60/10C6H55T	4.00	6.00	6.00	10.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/12C6H55T	4.00	6.00	6.00	12.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/16C6H55T	4.00	6.00	6.00	16.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/20C6H60T	4.00	6.00	6.00	20.0	60.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/25C6H60T	4.00	6.00	6.00	25.0	60.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/30C6H70T	4.00	6.00	6.00	30.0	70.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/35C6H75T	4.00	6.00	6.00	35.0	75.00	3.90	2	30.0	C	●	0.0300-0.0680
EC-A2 040-60/40C6H80T	4.00	6.00	6.00	40.0	80.00	3.90	2	30.0	C	●	0.0300-0.0680

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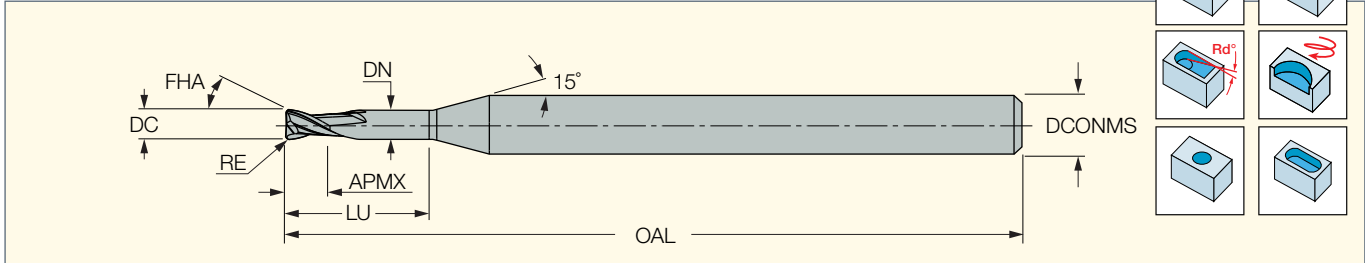
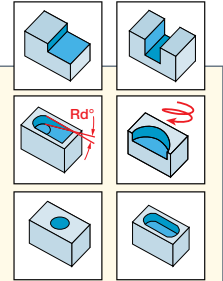
METRIC

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PREMIUM LINE

EC-A2-R-T

2 Flute Endmill with a Corner Radius for High Speed Machining Hardened Steel of Up to 65 HRc

<https://www.iscar.com/eCatalog/Family.aspx?fnum=5133&mapp=ML&GFSTYP=M&srch=1>



Designation	Dimensions										IC602	Recommended Machining Data
	DC	DCONMS	APMX	RE	LU	OAL	DN	NOF ⁽¹⁾	FHA	Shank		f _z (mm/t)
EC-A2 003-04/1C4R005H45T	0.30	4.00	0.40	0.05	1.0	45.00	0.27	2	30.0	C	●	0.0060-0.0100
EC-A2 003-04/2C4R005H45T	0.30	4.00	0.40	0.05	2.0	45.00	0.27	2	30.0	C	●	0.0060-0.0100
EC-A2 003-04/3C4R005H45T	0.30	4.00	0.40	0.05	3.0	45.00	0.27	2	30.0	C	●	0.0060-0.0100
EC-A2 004-06/1C4R005H45T	0.40	4.00	0.60	0.05	1.0	45.00	0.37	2	30.0	C	●	0.0060-0.0100
EC-A2 004-06/15C4R005H45T	0.40	4.00	0.60	0.05	1.5	45.00	0.37	2	30.0	C	●	0.0060-0.0100
EC-A2 004-06/25C4R005H45T	0.40	4.00	0.60	0.05	2.5	45.00	0.37	2	30.0	C	●	0.0060-0.0100
EC-A2 004-06/3C4R005H45T	0.40	4.00	0.60	0.05	3.0	45.00	0.37	2	30.0	C	●	0.0060-0.0100
EC-A2 004-06/4C4R005H45T	0.40	4.00	0.60	0.05	4.0	45.00	0.37	2	30.0	C	●	0.0060-0.0100
EC-A2 005-07/1C4R005H45T	0.50	4.00	0.70	0.05	1.0	45.00	0.45	2	30.0	C	●	0.0060-0.0100
EC-A2 005-07/15C4R005H45T	0.50	4.00	0.70	0.05	1.5	45.00	0.45	2	30.0	C	●	0.0060-0.0100
EC-A2 005-07/25C4R005H45T	0.50	4.00	0.70	0.05	2.5	45.00	0.45	2	30.0	C	●	0.0060-0.0090
EC-A2 005-07/3C4R005H45T	0.50	4.00	0.70	0.05	3.0	45.00	0.45	2	30.0	C	●	0.0060-0.0090
EC-A2 005-07/4C4R005H45T	0.50	4.00	0.70	0.05	4.0	45.00	0.45	2	30.0	C	●	0.0060-0.0080
EC-A2 006-09/2C4R005H45T	0.60	4.00	0.90	0.05	2.0	45.00	0.55	2	30.0	C	●	0.0080-0.0130
EC-A2 006-09/2C4R010H45T	0.60	4.00	0.90	0.10	2.0	45.00	0.55	2	30.0	C	●	0.0080-0.0130
EC-A2 006-09/2C4R020H45T	0.60	4.00	0.90	0.20	2.0	45.00	0.55	2	30.0	C	●	0.0080-0.0130
EC-A2 006-09/4C4R005H45T	0.60	4.00	0.90	0.05	4.0	45.00	0.55	2	30.0	C	●	0.0080-0.0130
EC-A2 006-09/4C4R010H45T	0.60	4.00	0.90	0.10	4.0	45.00	0.55	2	30.0	C	●	0.0080-0.0130
EC-A2 006-09/4C4R020H45T	0.60	4.00	0.90	0.20	4.0	45.00	0.55	2	30.0	C	●	0.0080-0.0130
EC-A2 006-09/6C4R005H45T	0.60	4.00	0.90	0.05	6.0	45.00	0.55	2	30.0	C	●	0.0080-0.0130
EC-A2 006-09/6C4R010H45T	0.60	4.00	0.90	0.10	6.0	45.00	0.55	2	30.0	C	●	0.0080-0.0130
EC-A2 006-09/6C4R020H45T	0.60	4.00	0.90	0.20	6.0	45.00	0.55	2	30.0	C	●	0.0080-0.0130
EC-A2 008-12/2C4R005H45T	0.80	4.00	1.20	0.05	2.0	45.00	0.75	2	30.0	C	●	0.0070-0.0150
EC-A2 008-12/2C4R010H45T	0.80	4.00	1.20	0.10	2.0	45.00	0.75	2	30.0	C	●	0.0070-0.0150
EC-A2 008-12/2C4R020H45T	0.80	4.00	1.20	0.20	2.0	45.00	0.75	2	30.0	C	●	0.0070-0.0150
EC-A2 008-12/4C4R005H45T	0.80	4.00	1.20	0.05	4.0	45.00	0.75	2	30.0	C	●	0.0070-0.0150
EC-A2 008-12/4C4R010H45T	0.80	4.00	1.20	0.10	4.0	45.00	0.75	2	30.0	C	●	0.0070-0.0150
EC-A2 008-12/4C4R020H45T	0.80	4.00	1.20	0.20	4.0	45.00	0.75	2	30.0	C	●	0.0070-0.0150
EC-A2 008-12/6C4R005H45T	0.80	4.00	1.20	0.05	6.0	45.00	0.75	2	30.0	C	●	0.0070-0.0150
EC-A2 008-12/6C4R010H45T	0.80	4.00	1.20	0.10	6.0	45.00	0.75	2	30.0	C	●	0.0070-0.0150
EC-A2 008-12/6C4R020H45T	0.80	4.00	1.20	0.20	6.0	45.00	0.75	2	30.0	C	●	0.0070-0.0150
EC-A2 008-12/8C4R005H45T	0.80	4.00	1.20	0.05	8.0	45.00	0.73	2	30.0	C	●	0.0070-0.0130
EC-A2 008-12/8C4R010H45T	0.80	4.00	1.20	0.10	8.0	45.00	0.73	2	30.0	C	●	0.0070-0.0130
EC-A2 008-12/8C4R020H45T	0.80	4.00	1.20	0.20	8.0	45.00	0.73	2	30.0	C	●	0.0070-0.0130
EC-A2 010-20/10C4R005H50T	1.00	4.00	2.00	0.05	10.0	50.00	0.95	2	30.0	C	●	0.0090-0.0160
EC-A2 010-20/10C4R010H50T	1.00	4.00	2.00	0.10	10.0	50.00	0.95	2	30.0	C	●	0.0090-0.0160
EC-A2 010-20/10C4R020H50T	1.00	4.00	2.00	0.20	10.0	50.00	0.95	2	30.0	C	●	0.0090-0.0160
EC-A2 010-20/10C4R030H50T	1.00	4.00	2.00	0.30	10.0	50.00	0.95	2	30.0	C	●	0.0090-0.0160
EC-A2 010-20/3C4R005H50T	1.00	4.00	2.00	0.05	3.0	50.00	0.97	2	30.0	C	●	0.0090-0.0200
EC-A2 010-20/3C4R010H50T	1.00	4.00	2.00	0.10	3.0	50.00	0.97	2	30.0	C	●	0.0090-0.0200
EC-A2 010-20/3C4R020H50T	1.00	4.00	2.00	0.20	3.0	50.00	0.97	2	30.0	C	●	0.0090-0.0200

⁽¹⁾ Number of flutes

NPA New Product Announcement

MILLING

48-2024

AUGUST 2024

METRIC

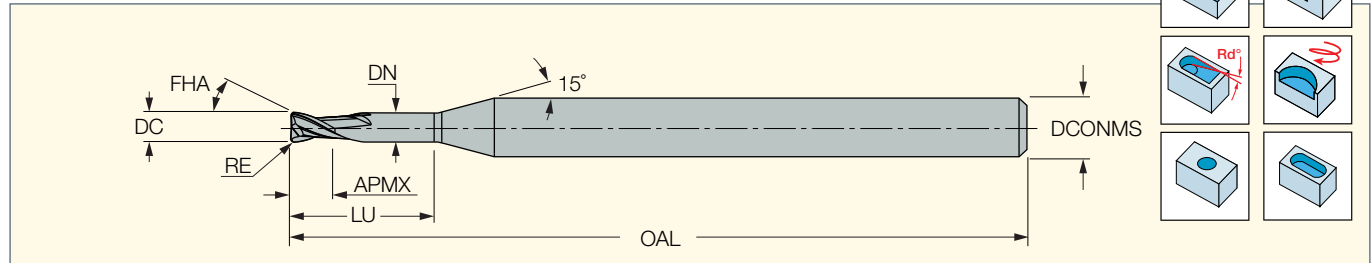
SOLIDMILL
PREMIUM LINE

continued

EC-A2-R-T

2 Flute Endmill with a Corner Radius for High Speed Machining Hardened Steel of Up to 65 HRc

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Designation	Dimensions										IC602	Recommended Machining Data
	DC	DCNMS	APMX	RE	LU	OAL	DN	NOF ⁽¹⁾	FHA	Shank		f _z (mm/t)
EC-A2 010-20/3C4R030H50T	1.00	4.00	2.00	0.30	3.0	50.00	0.97	2	30.0	C	●	0.0090-0.0200
EC-A2 010-20/4C4R005H50T	1.00	4.00	2.00	0.05	4.0	50.00	0.97	2	30.0	C	●	0.0090-0.0200
EC-A2 010-20/4C4R010H50T	1.00	4.00	2.00	0.10	4.0	50.00	0.97	2	30.0	C	●	0.0090-0.0200
EC-A2 010-20/4C4R020H50T	1.00	4.00	2.00	0.20	4.0	50.00	0.97	2	30.0	C	●	0.0090-0.0200
EC-A2 010-20/4C4R030H50T	1.00	4.00	2.00	0.30	4.0	50.00	0.97	2	30.0	C	●	0.0090-0.0200
EC-A2 010-20/6C4R005H50T	1.00	4.00	2.00	0.05	6.0	50.00	0.97	2	30.0	C	●	0.0090-0.0180
EC-A2 010-20/6C4R010H50T	1.00	4.00	2.00	0.10	6.0	50.00	0.97	2	30.0	C	●	0.0090-0.0180
EC-A2 010-20/6C4R020H50T	1.00	4.00	2.00	0.20	6.0	50.00	0.97	2	30.0	C	●	0.0090-0.0180
EC-A2 010-20/6C4R030H50T	1.00	4.00	2.00	0.30	6.0	50.00	0.97	2	30.0	C	●	0.0090-0.0180
EC-A2 010-20/8C4R005H50T	1.00	4.00	2.00	0.05	8.0	50.00	0.95	2	30.0	C	●	0.0090-0.0180
EC-A2 010-20/8C4R010H50T	1.00	4.00	2.00	0.10	8.0	50.00	0.95	2	30.0	C	●	0.0090-0.0180
EC-A2 010-20/8C4R020H50T	1.00	4.00	2.00	0.20	8.0	50.00	0.95	2	30.0	C	●	0.0090-0.0180
EC-A2 010-20/8C4R030H50T	1.00	4.00	2.00	0.30	8.0	50.00	0.95	2	30.0	C	●	0.0090-0.0180
EC-A2 012-22/10C4R010H50T	1.20	4.00	2.20	0.10	10.0	50.00	1.15	2	30.0	C	●	0.0100-0.0190
EC-A2 012-22/10C4R020H50T	1.20	4.00	2.20	0.20	10.0	50.00	1.15	2	30.0	C	●	0.0100-0.0190
EC-A2 012-22/10C4R030H50T	1.20	4.00	2.20	0.30	10.0	50.00	1.15	2	30.0	C	●	0.0100-0.0190
EC-A2 012-22/4C4R010H50T	1.20	4.00	2.20	0.10	4.0	50.00	1.17	2	30.0	C	●	0.0100-0.0200
EC-A2 012-22/4C4R020H50T	1.20	4.00	2.20	0.20	4.0	50.00	1.17	2	30.0	C	●	0.0100-0.0200
EC-A2 012-22/4C4R030H50T	1.20	4.00	2.20	0.30	4.0	50.00	1.17	2	30.0	C	●	0.0100-0.0200
EC-A2 012-22/6C4R010H50T	1.20	4.00	2.20	0.10	6.0	50.00	1.17	2	30.0	C	●	0.0100-0.0200
EC-A2 012-22/6C4R020H50T	1.20	4.00	2.20	0.20	6.0	50.00	1.17	2	30.0	C	●	0.0100-0.0200
EC-A2 012-22/6C4R030H50T	1.20	4.00	2.20	0.30	6.0	50.00	1.17	2	30.0	C	●	0.0100-0.0200
EC-A2 012-22/8C4R010H50T	1.20	4.00	2.20	0.10	8.0	50.00	1.15	2	30.0	C	●	0.0100-0.0200
EC-A2 012-22/8C4R020H50T	1.20	4.00	2.20	0.20	8.0	50.00	1.15	2	30.0	C	●	0.0100-0.0200
EC-A2 012-22/8C4R030H50T	1.20	4.00	2.20	0.30	8.0	50.00	1.15	2	30.0	C	●	0.0100-0.0200
EC-A2 015-25/10C4R005H50T	1.50	4.00	2.50	0.05	10.0	50.00	1.45	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/10C4R010H50T	1.50	4.00	2.50	0.10	10.0	50.00	1.45	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/10C4R020H50T	1.50	4.00	2.50	0.20	10.0	50.00	1.45	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/10C4R030H50T	1.50	4.00	2.50	0.30	10.0	50.00	1.45	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/10C4R050H50T	1.50	4.00	2.50	0.50	10.0	50.00	1.45	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/12C4R005H50T	1.50	4.00	2.50	0.05	12.0	50.00	1.43	2	30.0	C	●	0.0130-0.0250
EC-A2 015-25/12C4R010H50T	1.50	4.00	2.50	0.10	12.0	50.00	1.43	2	30.0	C	●	0.0130-0.0250
EC-A2 015-25/12C4R020H50T	1.50	4.00	2.50	0.20	12.0	50.00	1.43	2	30.0	C	●	0.0130-0.0250
EC-A2 015-25/12C4R030H50T	1.50	4.00	2.50	0.30	12.0	50.00	1.43	2	30.0	C	●	0.0130-0.0250
EC-A2 015-25/12C4R050H50T	1.50	4.00	2.50	0.50	12.0	50.00	1.43	2	30.0	C	●	0.0130-0.0250
EC-A2 015-25/4C4R010H50T	1.50	4.00	2.50	0.10	4.0	50.00	1.47	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/4C4R020H50T	1.50	4.00	2.50	0.20	4.0	50.00	1.47	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/4C4R030H50T	1.50	4.00	2.50	0.30	4.0	50.00	1.47	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/4C4R050H50T	1.50	4.00	2.50	0.50	4.0	50.00	1.47	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/6C4R005H50T	1.50	4.00	2.50	0.05	6.0	50.00	1.47	2	30.0	C	●	0.0150-0.0250

⁽¹⁾ Number of flutes

NPA New Product Announcement

MILLING

48-2024

AUGUST 2024

METRIC

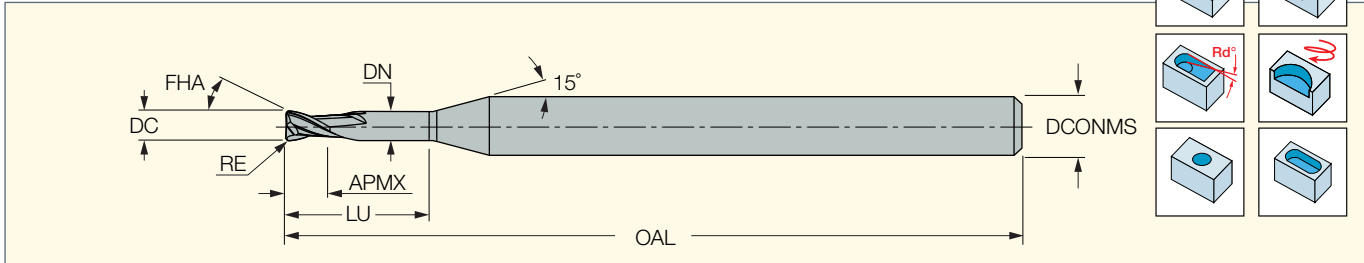
SOLIDMILL
PREMIUM LINE

continued

EC-A2-R-T

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Designation	Dimensions										IC602	Recommended Machining Data
	DC	DCONMS	APMX	RE	LU	OAL	DN	NOF ⁽¹⁾	FHA	Shank		f _z (mm/t)
EC-A2 015-25/6C4R010H50T	1.50	4.00	2.50	0.10	6.0	50.00	1.47	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/6C4R020H50T	1.50	4.00	2.50	0.20	6.0	50.00	1.47	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/6C4R030H50T	1.50	4.00	2.50	0.30	6.0	50.00	1.47	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/6C4R050H50T	1.50	4.00	2.50	0.50	6.0	50.00	1.47	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/8C4R005H50T	1.50	4.00	2.50	0.05	8.0	50.00	1.45	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/8C4R010H50T	1.50	4.00	2.50	0.10	8.0	50.00	1.45	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/8C4R020H50T	1.50	4.00	2.50	0.20	8.0	50.00	1.45	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/8C4R030H50T	1.50	4.00	2.50	0.30	8.0	50.00	1.45	2	30.0	C	●	0.0150-0.0250
EC-A2 015-25/8C4R050H50T	1.50	4.00	2.50	0.50	8.0	50.00	1.45	2	30.0	C	●	0.0150-0.0250
EC-A2 020-30/10C4R010H50T	2.00	4.00	3.00	0.10	10.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 020-30/10C4R020H50T	2.00	4.00	3.00	0.20	10.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 020-30/10C4R030H50T	2.00	4.00	3.00	0.30	10.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 020-30/10C4R050H50T	2.00	4.00	3.00	0.50	10.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 020-30/12C4R010H50T	2.00	4.00	3.00	0.10	12.0	50.00	1.93	2	30.0	C	●	0.0160-0.0250
EC-A2 020-30/12C4R020H50T	2.00	4.00	3.00	0.20	12.0	50.00	1.93	2	30.0	C	●	0.0160-0.0250
EC-A2 020-30/12C4R030H50T	2.00	4.00	3.00	0.30	12.0	50.00	1.93	2	30.0	C	●	0.0160-0.0250
EC-A2 020-30/12C4R050H50T	2.00	4.00	3.00	0.50	12.0	50.00	1.93	2	30.0	C	●	0.0160-0.0250
EC-A2 020-30/16C4R010H50T	2.00	4.00	3.00	0.10	16.0	50.00	1.91	2	30.0	C	●	0.0150-0.0220
EC-A2 020-30/16C4R020H50T	2.00	4.00	3.00	0.20	16.0	50.00	1.91	2	30.0	C	●	0.0150-0.0220
EC-A2 020-30/16C4R030H50T	2.00	4.00	3.00	0.30	16.0	50.00	1.91	2	30.0	C	●	0.0150-0.0220
EC-A2 020-30/16C4R050H50T	2.00	4.00	3.00	0.50	16.0	50.00	1.91	2	30.0	C	●	0.0150-0.0220
EC-A2 020-30/20C4R010H50T	2.00	4.00	3.00	0.10	20.0	50.00	1.91	2	30.0	C	●	0.0130-0.0190
EC-A2 020-30/20C4R020H50T	2.00	4.00	3.00	0.20	20.0	50.00	1.91	2	30.0	C	●	0.0130-0.0190
EC-A2 020-30/20C4R030H50T	2.00	4.00	3.00	0.30	20.0	50.00	1.91	2	30.0	C	●	0.0130-0.0190
EC-A2 020-30/20C4R050H50T	2.00	4.00	3.00	0.50	20.0	50.00	1.91	2	30.0	C	●	0.0130-0.0190
EC-A2 020-30/6C4R010H50T	2.00	4.00	3.00	0.10	6.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 020-30/6C4R020H50T	2.00	4.00	3.00	0.20	6.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 020-30/6C4R030H50T	2.00	4.00	3.00	0.30	6.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 020-30/6C4R050H50T	2.00	4.00	3.00	0.50	6.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 020-30/8C4R010H50T	2.00	4.00	3.00	0.10	8.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 020-30/8C4R020H50T	2.00	4.00	3.00	0.20	8.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 020-30/8C4R030H50T	2.00	4.00	3.00	0.30	8.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 020-30/8C4R050H50T	2.00	4.00	3.00	0.50	8.0	50.00	1.95	2	30.0	C	●	0.0180-0.0400
EC-A2 025-35/10C4R020H55T	2.50	4.00	3.50	0.20	10.0	55.00	2.40	2	30.0	C	●	0.0190-0.0450
EC-A2 025-35/10C4R030H55T	2.50	4.00	3.50	0.30	10.0	55.00	2.40	2	30.0	C	●	0.0190-0.0450
EC-A2 025-35/10C4R050H55T	2.50	4.00	3.50	0.50	10.0	55.00	2.40	2	30.0	C	●	0.0190-0.0450
EC-A2 025-35/12C4R020H55T	2.50	4.00	3.50	0.20	12.0	55.00	2.40	2	30.0	C	●	0.0170-0.0400
EC-A2 025-35/12C4R030H55T	2.50	4.00	3.50	0.30	12.0	55.00	2.40	2	30.0	C	●	0.0170-0.0400

⁽¹⁾ Number of flutes

NPA New Product Announcement

MILLING

48-2024

AUGUST 2024

METRIC

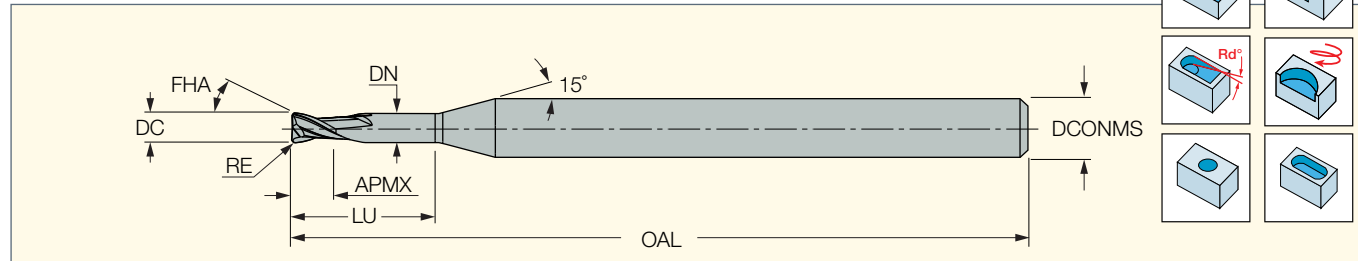
SOLIDMILL
PREMIUM LINE

continued

EC-A2-R-T

2 Flute Endmill with a Corner Radius for High Speed Machining Hardened Steel of Up to 65 HRc

<https://www.iscar.com/eCatalog/Family.aspx?num=5133&mapp=ML&GFSTYP=M&srch=1>



Designation	Dimensions										IC602	Recommended Machining Data
	DC	DCONMS	APMX	RE	LU	OAL	DN	NOF ⁽¹⁾	FHA	Shank		f _z (mm/t)
EC-A2 025-35/12C4R050H55T	2.50	4.00	3.50	0.50	12.0	55.00	2.40	2	30.0	C	●	0.0170-0.0400
EC-A2 025-35/16C4R020H55T	2.50	4.00	3.50	0.20	16.0	55.00	2.40	2	30.0	C	●	0.0150-0.0300
EC-A2 025-35/16C4R030H55T	2.50	4.00	3.50	0.30	16.0	55.00	2.40	2	30.0	C	●	0.0150-0.0300
EC-A2 025-35/16C4R050H55T	2.50	4.00	3.50	0.50	16.0	55.00	2.40	2	30.0	C	●	0.0150-0.0300
EC-A2 025-35/8C4R020H55T	2.50	4.00	3.50	0.20	8.0	55.00	2.40	2	30.0	C	●	0.0190-0.0450
EC-A2 025-35/8C4R030H55T	2.50	4.00	3.50	0.30	8.0	55.00	2.40	2	30.0	C	●	0.0190-0.0450
EC-A2 025-35/8C4R050H55T	2.50	4.00	3.50	0.50	8.0	55.00	2.40	2	30.0	C	●	0.0190-0.0450
EC-A2 030-45/10C6R010H55T	3.00	6.00	4.50	0.10	10.0	55.00	2.85	2	30.0	C	●	0.0210-0.0600
EC-A2 030-45/10C6R020H55T	3.00	6.00	4.50	0.20	10.0	55.00	2.85	2	30.0	C	●	0.0210-0.0600
EC-A2 030-45/10C6R030H55T	3.00	6.00	4.50	0.30	10.0	55.00	2.85	2	30.0	C	●	0.0210-0.0600
EC-A2 030-45/10C6R050H55T	3.00	6.00	4.50	0.50	10.0	55.00	2.85	2	30.0	C	●	0.0210-0.0600
EC-A2 030-45/10C6R100H55T	3.00	6.00	4.50	1.00	10.0	55.00	2.85	2	30.0	C	●	0.0210-0.0600
EC-A2 030-45/12C6R010H55T	3.00	6.00	4.50	0.10	12.0	55.00	2.85	2	30.0	C	●	0.0180-0.0500
EC-A2 030-45/12C6R020H55T	3.00	6.00	4.50	0.20	12.0	55.00	2.85	2	30.0	C	●	0.0180-0.0500
EC-A2 030-45/12C6R030H55T	3.00	6.00	4.50	0.30	12.0	55.00	2.85	2	30.0	C	●	0.0180-0.0500
EC-A2 030-45/12C6R050H55T	3.00	6.00	4.50	0.50	12.0	55.00	2.85	2	30.0	C	●	0.0180-0.0500
EC-A2 030-45/12C6R100H55T	3.00	6.00	4.50	1.00	12.0	55.00	2.85	2	30.0	C	●	0.0180-0.0500
EC-A2 030-45/16C6R010H55T	3.00	6.00	4.50	0.10	16.0	55.00	2.85	2	30.0	C	●	0.0180-0.0450
EC-A2 030-45/16C6R020H55T	3.00	6.00	4.50	0.20	16.0	55.00	2.85	2	30.0	C	●	0.0180-0.0450
EC-A2 030-45/16C6R030H55T	3.00	6.00	4.50	0.30	16.0	55.00	2.85	2	30.0	C	●	0.0180-0.0450
EC-A2 030-45/16C6R050H55T	3.00	6.00	4.50	0.50	16.0	55.00	2.85	2	30.0	C	●	0.0180-0.0450
EC-A2 030-45/16C6R100H55T	3.00	6.00	4.50	1.00	16.0	55.00	2.85	2	30.0	C	●	0.0180-0.0450
EC-A2 030-45/20C6R010H60T	3.00	6.00	4.50	0.10	20.0	60.00	2.85	2	30.0	C	●	0.0150-0.0400
EC-A2 030-45/20C6R020H60T	3.00	6.00	4.50	0.20	20.0	60.00	2.85	2	30.0	C	●	0.0150-0.0400
EC-A2 030-45/20C6R030H60T	3.00	6.00	4.50	0.30	20.0	60.00	2.85	2	30.0	C	●	0.0150-0.0400
EC-A2 030-45/20C6R050H60T	3.00	6.00	4.50	0.50	20.0	60.00	2.85	2	30.0	C	●	0.0150-0.0400
EC-A2 030-45/20C6R100H60T	3.00	6.00	4.50	0.00	20.0	60.00	2.85	2	30.0	C	●	0.0150-0.0400
EC-A2 030-45/25C6R010H60T	3.00	6.00	4.50	0.10	25.0	60.00	2.85	2	30.0	C	●	0.0150-0.0400
EC-A2 030-45/25C6R020H60T	3.00	6.00	4.50	0.20	25.0	60.00	2.85	2	30.0	C	●	0.0150-0.0400
EC-A2 030-45/25C6R030H60T	3.00	6.00	4.50	0.30	25.0	60.00	2.85	2	30.0	C	●	0.0150-0.0400
EC-A2 030-45/25C6R050H60T	3.00	6.00	4.50	0.50	25.0	60.00	2.85	2	30.0	C	●	0.0150-0.0400
EC-A2 030-45/8C6R010H55T	3.00	6.00	4.50	0.10	8.0	55.00	2.85	2	30.0	C	●	0.0210-0.0600
EC-A2 030-45/8C6R020H55T	3.00	6.00	4.50	0.20	8.0	55.00	2.85	2	30.0	C	●	0.0210-0.0600
EC-A2 030-45/8C6R030H55T	3.00	6.00	4.50	0.30	8.0	55.00	2.85	2	30.0	C	●	0.0210-0.0600
EC-A2 030-45/8C6R050H55T	3.00	6.00	4.50	0.50	8.0	55.00	2.85	2	30.0	C	●	0.0210-0.0600
EC-A2 030-45/8C6R100H55T	3.00	6.00	4.50	1.00	8.0	55.00	2.85	2	30.0	C	●	0.0210-0.0600
EC-A2 040-60/10C6R010H55T	4.00	6.00	6.00	0.10	10.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/10C6R020H55T	4.00	6.00	6.00	0.20	10.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750

⁽¹⁾ Number of flutes

NPA New Product Announcement

MILLING

48-2024

AUGUST 2024

METRIC

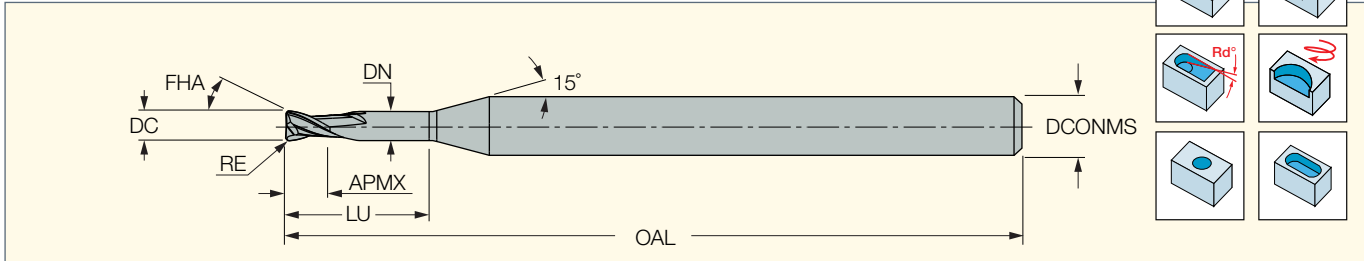
SOLIDMILL
PREMIUM LINE

continued

EC-A2-R-T

2 Flute Endmill with a Corner Radius for High Speed Machining Hardened Steel of Up to 65 HRc

<https://www.iscar.com/eCatalog/Family.aspx?fnm=5133&mapp=ML&GFSTYP=M&srch=1>



Designation	Dimensions										IC602	Recommended Machining Data
	DC	DCONMS	APMX	RE	LU	OAL	DN	NOF ⁽¹⁾	FHA	Shank		f _z (mm/t)
EC-A2 040-60/10C6R030H55T	4.00	6.00	6.00	0.30	10.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/10C6R050H55T	4.00	6.00	6.00	0.50	10.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/10C6R100H55T	4.00	6.00	6.00	1.00	10.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/12C6R010H55T	4.00	6.00	6.00	0.10	12.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/12C6R020H55T	4.00	6.00	6.00	0.20	12.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/12C6R030H55T	4.00	6.00	6.00	0.30	12.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/12C6R050H55T	4.00	6.00	6.00	0.50	12.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/12C6R100H55T	4.00	6.00	6.00	1.00	12.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/16C6R010H55T	4.00	6.00	6.00	0.10	16.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/16C6R020H55T	4.00	6.00	6.00	0.20	16.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/16C6R030H55T	4.00	6.00	6.00	0.30	16.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/16C6R050H55T	4.00	6.00	6.00	0.50	16.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/16C6R100H55T	4.00	6.00	6.00	1.00	16.0	55.00	3.90	2	30.0	C	●	0.0300-0.0750
EC-A2 040-60/20C6R010H60T	4.00	6.00	6.00	0.10	20.0	60.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/20C6R020H60T	4.00	6.00	6.00	0.20	20.0	60.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/20C6R030H60T	4.00	6.00	6.00	0.30	20.0	60.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/20C6R050H60T	4.00	6.00	6.00	0.50	20.0	60.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/20C6R100H60T	4.00	6.00	6.00	1.00	20.0	60.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/25C6R010H60T	4.00	6.00	6.00	0.10	25.0	60.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/25C6R020H60T	4.00	6.00	6.00	0.20	25.0	60.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/25C6R030H60T	4.00	6.00	6.00	0.30	25.0	60.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/25C6R050H60T	4.00	6.00	6.00	0.50	25.0	60.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/25C6R100H60T	4.00	6.00	6.00	1.00	25.0	60.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/30C6R010H70T	4.00	6.00	6.00	0.10	30.0	70.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/30C6R020H70T	4.00	6.00	6.00	0.20	30.0	70.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/30C6R030H70T	4.00	6.00	6.00	0.30	30.0	70.00	3.90	2	30.0	C	●	0.0300-0.0700
EC-A2 040-60/30C6R050H70T	4.00	6.00	6.00	0.50	30.0	70.00	3.90	2	30.0	C	●	0.0300-0.0700

⁽¹⁾ Number of flutes



2 FLUTE FOR RIB PROCESSING - SLOTTING (Ae=100%)

ISO	Material Group	Material	Condition	Hardness HB	Parameter	Ø DIAMETER [mm]											
						0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2-2.5	3.0	4.0	
P	1	<0.25% C	annealed	125	Vc [m/min]	41-47	39-63	40-52	39-66	41-66	39-59	39-66	43-83	40-66	41-66	40-67	
					Ap [mm]	0.006-0.015	0.005-0.028	0.006-0.035	0.007-0.030	0.009-0.040	0.011-0.028	0.025-0.070	0.017-0.077	0.021-0.140	0.056-0.210	0.074-0.280	
	2	≥0.25% C	annealed	190	Vc [m/min]	41-47	39-63	40-52	39-66	41-66	39-59	39-66	43-83	40-66	41-66	40-67	
					Ap [mm]	0.006-0.015	0.005-0.028	0.006-0.035	0.007-0.030	0.009-0.040	0.011-0.028	0.025-0.070	0.017-0.077	0.021-0.140	0.056-0.210	0.074-0.280	
	3	non-alloy steel and cast steel, free cutting steel	<0.55% C	quenched and tempered	250	Vc [m/min]	41-47	39-63	40-52	39-66	41-66	39-59	39-66	43-83	40-66	41-66	40-67
						Ap [mm]	0.006-0.015	0.005-0.028	0.006-0.035	0.007-0.030	0.009-0.040	0.011-0.028	0.025-0.070	0.017-0.077	0.021-0.140	0.056-0.210	0.074-0.280
	4	≥0.55% C	annealed	220	Vc [m/min]	41-47	39-63	40-52	39-66	41-66	39-59	39-66	43-83	40-66	41-66	40-67	
					Ap [mm]	0.006-0.015	0.005-0.028	0.006-0.035	0.007-0.030	0.009-0.040	0.011-0.028	0.025-0.070	0.017-0.077	0.021-0.140	0.056-0.210	0.074-0.280	
	5	quenched and tempered	300	Vc [m/min]	41-47	39-63	40-52	39-66	41-66	39-59	39-66	43-83	40-66	41-66	40-67		
				Ap [mm]	0.006-0.015	0.005-0.028	0.006-0.035	0.007-0.030	0.009-0.040	0.011-0.028	0.025-0.070	0.017-0.077	0.021-0.140	0.056-0.210	0.074-0.280		
	6	low alloy and cast steel (less than 5% of alloying elements)	annealed	200	Vc [m/min]	41-47	39-63	40-52	39-66	41-66	39-59	39-66	43-83	40-66	41-66	40-67	
Ap [mm]					0.006-0.015	0.005-0.028	0.006-0.035	0.007-0.030	0.009-0.040	0.011-0.028	0.025-0.070	0.017-0.077	0.021-0.140	0.056-0.210	0.074-0.280		
7	quenched and tempered	275	Vc [m/min]	41-47	39-63	40-52	39-66	41-66	39-59	39-66	43-83	40-66	41-66	40-67			
			Ap [mm]	0.006-0.015	0.005-0.028	0.006-0.035	0.007-0.030	0.009-0.040	0.011-0.028	0.025-0.070	0.017-0.077	0.021-0.140	0.056-0.210	0.074-0.280			
8	300	Vc [m/min]	41-47	39-63	40-52	39-66	41-66	39-59	39-66	43-83	40-66	41-66	40-67				
		Ap [mm]	0.006-0.015	0.005-0.028	0.006-0.035	0.007-0.030	0.009-0.040	0.011-0.028	0.025-0.070	0.017-0.077	0.021-0.140	0.056-0.210	0.074-0.280				
9	350	Vc [m/min]	41-47	39-63	40-52	39-66	41-66	39-59	39-66	43-83	40-66	41-66	40-67				
		Ap [mm]	0.006-0.015	0.005-0.028	0.006-0.035	0.007-0.030	0.009-0.040	0.011-0.028	0.025-0.070	0.017-0.077	0.021-0.140	0.056-0.210	0.074-0.280				
10	annealed	200	Vc [m/min]	41-47	39-63	40-52	39-66	41-66	39-59	39-66	43-83	40-66	41-66	40-67			
			Ap [mm]	0.006-0.015	0.005-0.028	0.006-0.035	0.007-0.030	0.009-0.040	0.011-0.028	0.025-0.070	0.017-0.077	0.021-0.140	0.056-0.210	0.074-0.280			
11	high alloyed steel, cast steel and tool steel	quenched and tempered	325	Vc [m/min]	41-47	39-63	40-52	39-66	41-66	39-59	39-66	43-83	40-66	41-66	40-67		
				Ap [mm]	0.006-0.015	0.005-0.028	0.006-0.035	0.007-0.030	0.009-0.040	0.011-0.028	0.025-0.070	0.017-0.077	0.021-0.140	0.056-0.210	0.074-0.280		
H	38	hardened steel	Hardened	55 HRC	Vc [m/min]	38-44	38-44	37-41	38-41	38-42	33-36	34-38	33-38	38-42	38-43	38-43	
					Ap [mm]	0.004-0.011	0.003-0.020	0.004-0.025	0.005-0.021	0.006-0.028	0.008-0.020	0.015-0.042	0.012-0.055	0.015-0.100	0.040-0.150	0.053-0.200	
	39	Hardened	60 HRC	Vc [m/min]	23-30	23-31	22-28	22-29	23-29	20-25	20-26	20-26	23-30	23-30	23-30		
				Ap [mm]	0.003-0.007	0.002-0.012	0.003-0.015	0.003-0.013	0.004-0.017	0.005-0.012	0.009-0.026	0.007-0.033	0.009-0.060	0.024-0.090	0.032-0.120		
40	chilled cast iron	Cast	400	Vc [m/min]	41-47	39-63	40-52	39-66	41-66	39-59	39-66	53-83	40-66	41-66	40-67		
				Ap [mm]	0.006-0.015	0.005-0.028	0.006-0.035	0.007-0.030	0.009-0.040	0.011-0.028	0.025-0.070	0.017-0.077	0.021-0.140	0.056-0.210	0.074-0.280		
41	cast iron	Hardened	55 HRC	Vc [m/min]	38-44	38-44	37-41	38-41	38-42	33-36	34-38	33-38	38-42	38-43	38-43		
				Ap [mm]	0.004-0.011	0.003-0.020	0.004-0.025	0.005-0.021	0.006-0.028	0.008-0.020	0.015-0.042	0.012-0.055	0.015-0.100	0.040-0.150	0.053-0.200		